



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-698-013
Job Sheet 179780



Part No: D412-698-013

Job Qty: 2 ea

Part Name: Cabin Door Handle - Aluminum Door



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 6/29/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: IIN-D412-698 REV.G IPP Rev: C Removed Manufacturing 05-11-06 JLM IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Stores/Pkg-2	6-8	JUN 25 2018
110	Packaging	2 pcs	6/29/18	6/29/18	0.00	0.00	Packaging1-4	6-8	JUL 12 2018
120	QC	2 pcs	6/29/18	6/29/18	0.00	0.00	QC4	9-8	DAS
125	DC	2 pcs	6/29/18	6/29/18	0.00	0.00	DC	9-8	28
130	Packaging	2 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-2	DAS	9-89
140	QC21-FG	2 Ea	6/29/18	6/29/18	0.00	0.00	QC21	53	JUL 16 2018

Part Op 125 - Photocopy bluefile and create labels per PPP D412-698-013 CHG001
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3203-1	Handle	8 Ea (4 ea)	90-Start up Operation	5066933x3 58907 49x5
D3220-041	Doubler Assembly	2 Ea (1 ea)	90-Start up Operation	5035718
D3220-042	Doubler Assembly	2 Ea (1 ea)	90-Start up Operation	5042344
D3220-3	Doubler	4 Ea (2 ea)	90-Start up Operation	5035718
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	5067898
MS24694-S98	Screw	32 Ea (16 ea)	90-Start up Operation	5067898
NAS1149D0463J	Washer	16 Ea (8 ea)	90-Start up Operation	5067900

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3203-1	8	3	0
	D3220-041	2	5	0
	D3220-042	2	6	0
	D3220-3	4	8	0
	MS21042L4	16	2,309	0
	MS24694-S98	32	151	0
	NAS1149D0463J	16	4,028	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____	
Description Work Order Deviation			Disposition		
			Completed By _____		
			Signature / Supervisor _____ Initial Verification _____		
			Coordinator _____ Approval _____		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power ☐ Folio/P ☐ Grain ☐ Weld ☐ Wrong S ☐ Out of S ☐ Off-set ☐ Mislabel ☐ Fit/Function ☐ Misaligned/off center ☐		
			Date: 06/25/18 Uart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		
			d Wrong imensions er tolerance rect Missing d Finish Misread Turning Sequence		
			OTHER : _____		

Container No: S083825
 Part: D412 - 698 - 013
 Job No: 179780
 Serial No/Batch: S083825
 Revision: G
 Inspector: _____
 Exp Date: _____
 Instructions: _____

Part Specifications
Specifications could not be found.

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004064	S083823	D3220-041	Doubler Assembly	s035718	ST485	2
004064	S042344	D3220-042	Doubler Assembly	S044287	ST485	2
004064	S083824	D3220-3	Doubler	s035720	ST485	4
004064	S083822	MS21042L4	Nut	s067898	ST303	16
004064	S083821	MS24694-S98	Screw	fm135704-0	ST283	32
004064	S083820	NAS1149D0463J	Washer	s067900	ST263	16

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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6.0 PARTS LIST – CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Qty -027	Qty -028	Part Number	Description
X								D412-698-011	CABIN DOOR ROLLER KIT, LH
	X							D412-698-012	CABIN DOOR ROLLER KIT, RH
		X						D412-698-013	DOOR HANDLE KIT
			X					D412-698-017	REPLACEMENT DOOR TRACK KIT
				X				D412-698-019	BEARING OVERHAUL KIT
					X			D412-698-021	REPLACEMENT SHIM KIT
						X		D412-689-027	BRACKET KIT, LH (ALUMINUM DOORS)
							X	D412-689-028	BRACKET KIT, RH (ALUMINUM DOORS)
3	3							D3121-141	BRACKET ASSEMBLY
1								D3121-143	BRACKET ASSEMBLY
	1							D3121-144	BRACKET ASSEMBLY
1	1							D3137-043	BRACKET ASSEMBLY
1								D3183-043	BRACKET ASSEMBLY
	1							D3183-044	BRACKET ASSEMBLY
9	9		9					D3199-1	BRACKET
						1		D3199-3	FORWARD BRACKET, LH
							1	D3199-4	FORWARD BRACKET, RH
1	1		1					D3202-1	COVER
		4						D3203-1	HANDLE
		1						D3220-041	DOUBLER
		1						D3220-042	DOUBLER
		2						D3220-3	DOUBLER
				7				D3121-21	BOLT
				5				D3121-241	BEARING ASSEMBLY
				1				D3137-3	GUIDE
				1				D3137-5	WASHER
				2				D3183-045	BEARING ASSEMBLY
					3			D3238-1	SHIM
					1			D3238-3	SHIM
					2			D3238-5	SHIM
					6			D3238-11	SHIM
					2			D3238-13	SHIM
					4			D3238-15	SHIM
		8						NAS1149D0463J	WASHER (AN960JD416L)
		8						MS21042L4	NUT (OR MS21042-4)
		16						MS24694-S98	SCREW
				1				MS24694-S101	SCREW

REFERENCE ONLY

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Revision: G

Date: 17.11.23